

Work Order ID 50495



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July 10, 2009 2:45:04 PM

Item ID: D3831-1KIV
Revision ID: A-PROTO
Item Name: Rear Overhead, LH

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 09-07-10

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3831

A-PROTO 09.06.12

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/13 X1

M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up

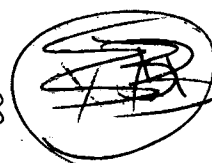
2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA058 using tool DT9072

Dwg Rev: *A*

Folio Rev: *A*

DT 9343



BB 09/07/13 X1

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
Hand Thermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

BB 09/07/16 (X1)

Dr. 09/07/16 (X1)

Dr. 09/07/16 (X1)

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Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00 0.00	Dt. 09/07/16 (81)				_____	_____	_____
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	RJ 09.07.20 ENGINEERING APPROVAL				_____	_____	_____
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	FOR ENG'G TEST RJ 09.07.20				_____	_____	_____

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July 10, 2009 2:45:04 PM

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Accept



Setup Start



Revision ID: A-PROTO

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Item Name: Rear Overhead, LH

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Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/28/09

W of 240709

Picklist Print

Page 1

July 10, 2009 2:45:03 PM

Work Order ID: 50495

Parent Item: D3831-1KIVRevA-PROTO

Parent Item Name: Rear Overhead, LH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	11.0940			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109703

894.5037653

894.503765

BB 09/07/13 (X1)

M109703

DART AEROSPACE LTD	Work Order: 50495
Description:	Part Number: 03831-1 KIU
Inspection Dwg: D3831-1 Rev: A PROTO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

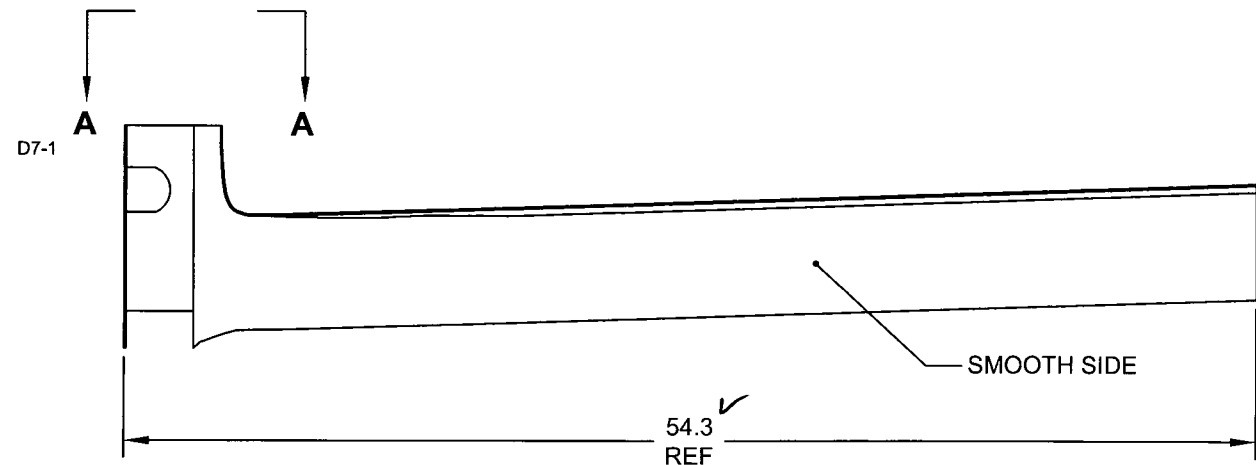
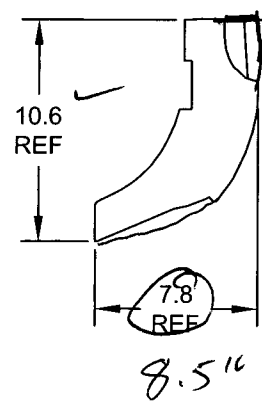
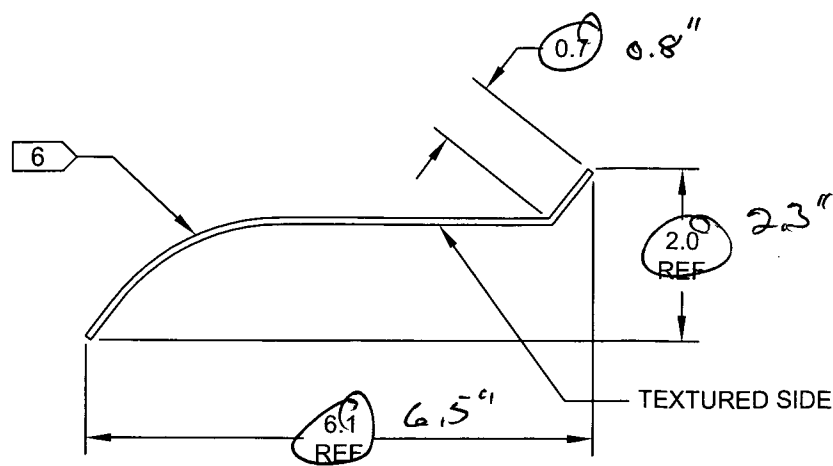
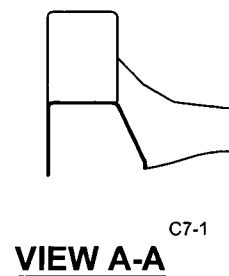
Measured by:	Date:
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.6"	Ref	10.6	✓			
7.5" 8.5"	Ref	8.5	✓			Also measured 7.5"
54.3"	Ref	54.3"	✓			
0.8"	±0.100	0.75"	✓			
2.3"	Ref	2.3"	✓			
6.5"	Ref	6.5"	✓			
0.050	MIN	0.060	✓			
0.040	MIN	0.047	✓			

Measured by: <i>D. Heger</i>	Date: 09/07/16
Audited by: <i>PH</i>	Date: 09.07.12
Prototype Approval: <i>PH</i>	Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



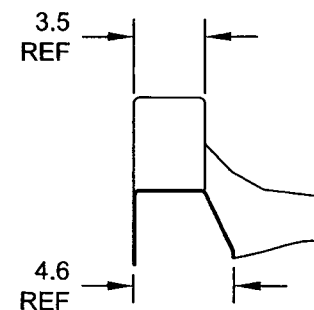
D3831-1 REAR OVERHEAD, LH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-16 *RH*

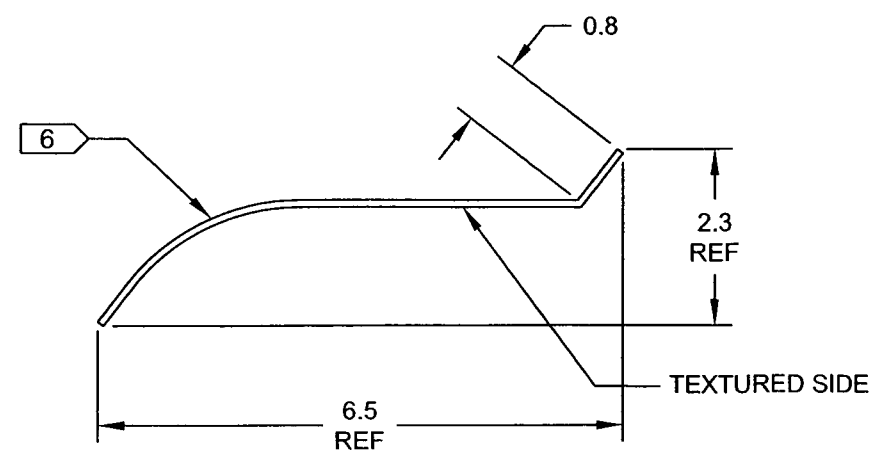
- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.4 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9343 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3831-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3831-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

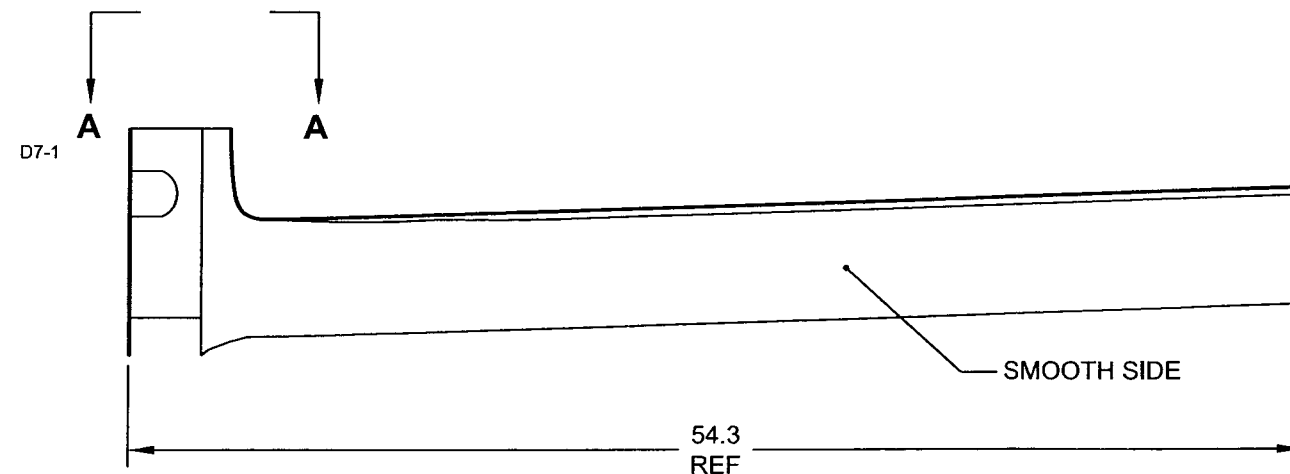
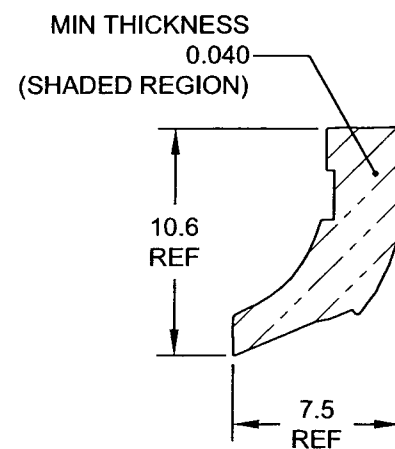
A	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED		DRAWING NO.	REV. A
DE APPR.		D3831	SHEET 1 OF 2
DATE	09.06.12	TITLE	SCALE
		REAR OVERHEAD	NTS
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VIEW A-A
C7-1



VIEW B
B3-1
(SCALE 4X, ROTATED CW)



VIEW B
C3-1

D3831-1 REAR OVERHEAD, LH

NOTES:

- 1) MATERIAL: SEE TABLE
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